

Date: Tuesday, 11/14/2006 10:03:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOOR PROTECTOR AFT RH
 Job Number : 29427
 Estimate Number : 11235
 P.O. Number : N/A Part Number : D32814
 This Issue : 11/14/2006 S.O. No. : N/A Drawing Number : D3281 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : B
 Previous Run : 27511 Material : N/A
 Due Date : 12/20/2006 Qty: 10 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est Rev: A 04.07.01 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 2495
 Description: Floor Protector Aft, RH
 Possible Supplier: Delastek
 Certificate of Conformity is required

CLocal 11/15

(10)

2.0 D32814P Floor Protector, Aft RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Floor Protector Aft, RH

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

12/01/24
 DIMENSIONAL CHECK

4.0 QC6



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

12/01/23 (10)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1




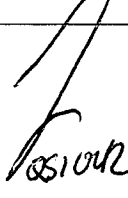

Identify and Stock
 Location: _____

12/01/23 (10) 12/01/23 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/23	H.O	Mark from the cutting tool on one part on a corner made from the Supplier		Part is still good	 07/01/23	 07/01/23		 07/01/23

NOTE: Date & initial all entries

Date: Tuesday, 11/14/2006 10:03:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 29427

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

LS 707101124

Job Completion



U 07-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

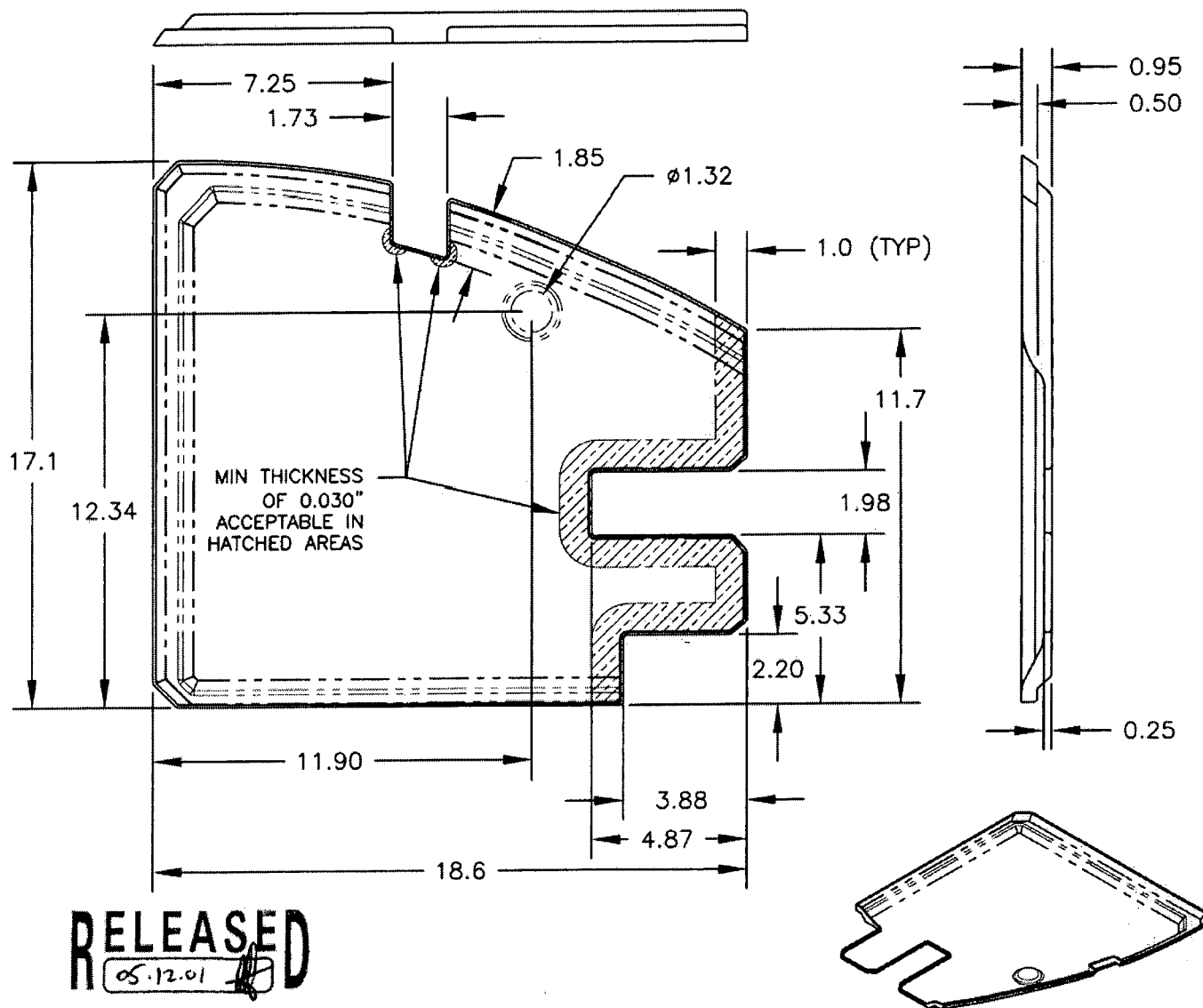
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

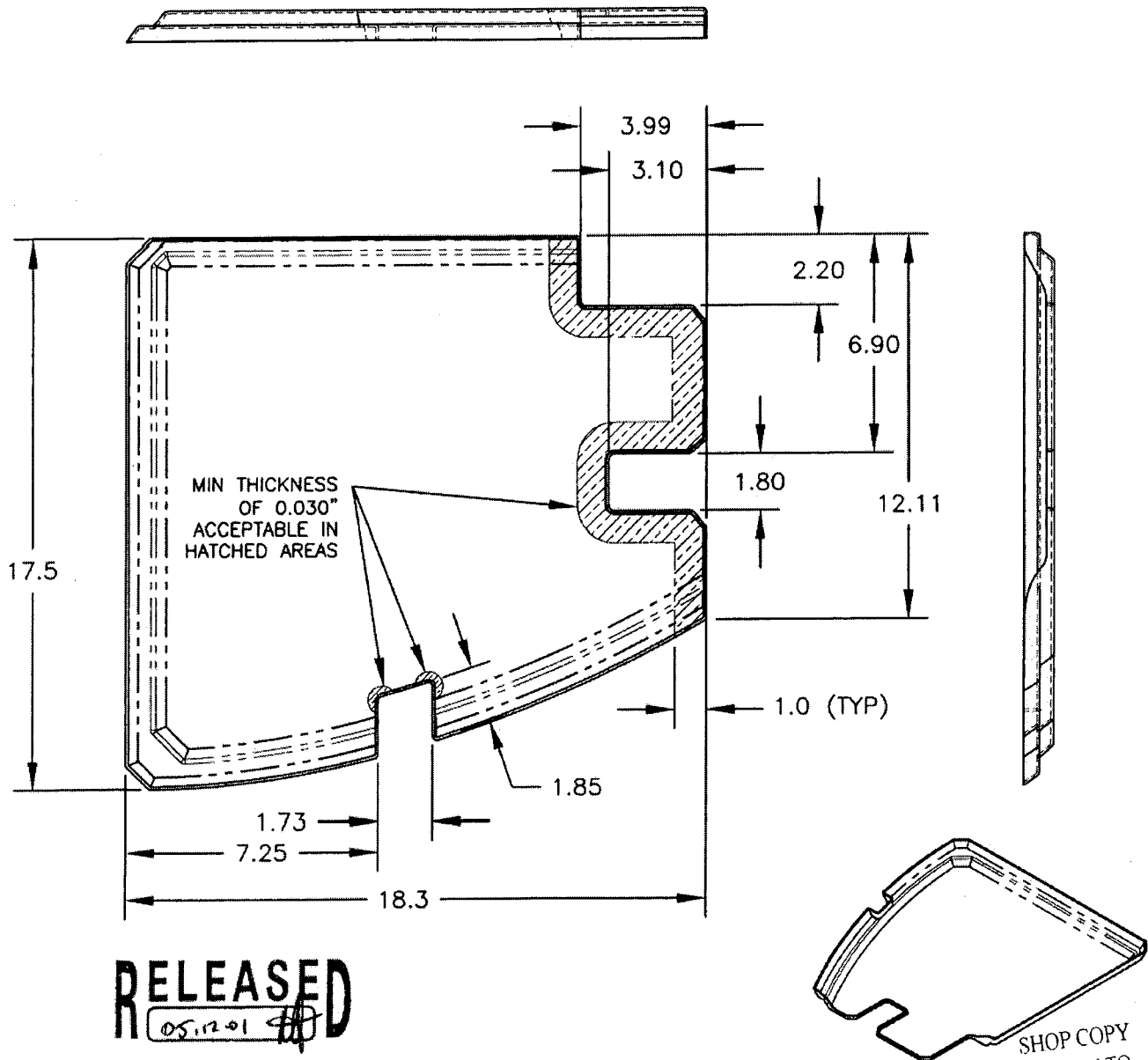
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WORK ORDER
29427

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CHECKED <i>HL</i>	APPROVED <i>HL</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01 *HL***D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

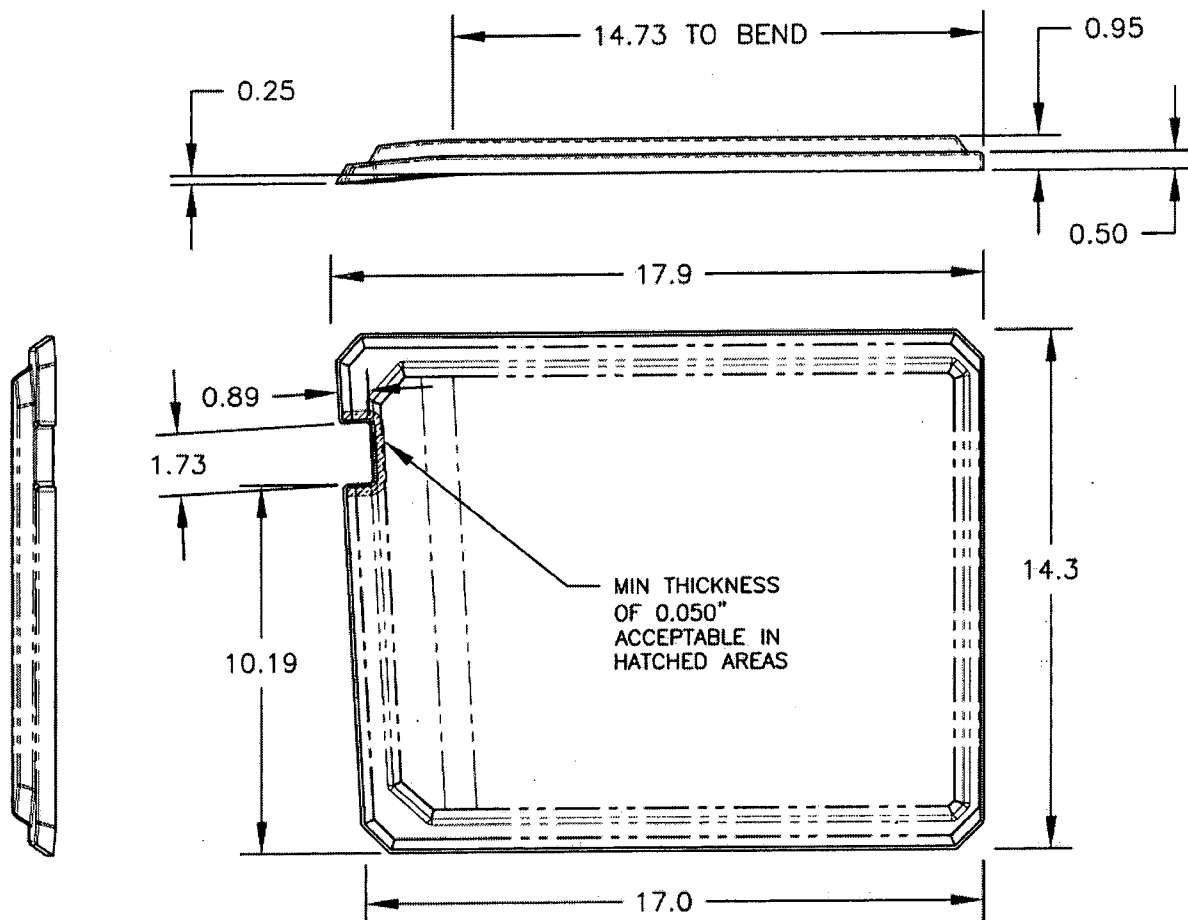
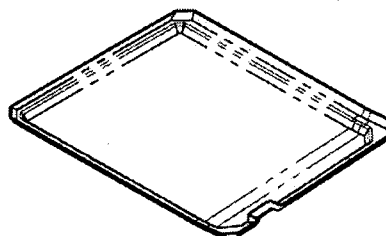
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5

**RELEASED**
05.12.01. *[Signature]*

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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DELASTEK COMPOSITES INC.
2699, 5^{ème} Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11497
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle


Ship Via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our P.O. #	Order by		Your P.O. #	GST/PST #	
19/01/07	15/11/06	5017	C. Lavoie		PO00002495		
Order Qty	B.O Qty	Current Ship	Item #	Item Description			
10	0	10	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) B29424 Selon dessin D3281 Rev.: B Job: 40353 U de M : Each			
10	0	10	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) B29426 Selon dessin D3281 Rev.: B Job: 40356 U de M : Each			
10	0	10	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) B29427 Selon dessin D3281 Rev.: B Job: 40357 U de M : Each			
<div>07/01/23</div>							

07/01/23

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:


19/01/07
Quality department AQ-357

te: Jeudi, 2006-11-16 15:07:40
 lisateur: Sylvie Hamel

Feuille de Procédé

 Client : DART Dart Aerospace Ltd.
 Numéro Job : 40357
 Numéro Soumission : 2386
 Numéro B.A. :
 Date : 2006-11-16 No. B.V. :
 Révisé Rev. : NC
 Rem. : - - Type :
 Job précédente : 36895
 Crit par :
 Vérifié & Approuvé par :
 Commentaires : N° de pièce: D3281-4

 Nom Dessin : FLOOR PROTECTOR AFT, LH
 Numéro Article : DKC134-0047
 Numéro Dessin : D3281
 Projet Numéro : DKC134
 Révision dessin : B
 Matériel : F6006
 Date Due : 2006-12-08

Qté:

25

18 UDM: UNITE

Process Sheet Rév.: 00 Création du premier



Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0 APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

 Commentaire Qty.: 0.167 UNITE(s)/Unit Total
 Lexan F6006 Noir N° 700 48" x 96"

APL0016

 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
 # Bon achat: 5913

3-5913-1

N° de Lot:

2.0 SÉCHAGE/ ANEAL


 Commentaire Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.5000Hrs
 SÉCHAGE DU MATÉRIEL

 Sécher le matériel dans le four à 250° F pendant 6 heures.
 Inscrire sur la charte de température le numéro de Job du matériel au séchage.
 # de cuisson: 5484

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART


 Commentaire Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 45.0000Hrs
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité:

Date:

11-1-07

Sceau:



Quantité:

Date:

Sceau:

ate: Jeudi, 2006-11-16 15:07:40
utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40357

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART



Commentair Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.



Quantité: 24 Date: 11-1-07 Sceau: _____

200g

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 24 Date: 12-1-07 Sceau: SB

~~200g~~

Quantité: _____ Date: _____ Sceau: _____

6.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 24 Date: 18-01-07 Sceau: SB



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

ite: Jeudi, 2006-11-16 15:07:40

lisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 40357

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-4

N° de Job: 40357

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 24 Date: 15-1-07 Sceau: RB

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair: Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs

EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: _____

N° de job: _____

Quantité: 24 Date: 18/1/07 Sceau:

Quantité: _____ Date: _____ Sceau: _____